Work Order ID 73831

Friday, September 16, 2011 11:43:35 AM

Item ID: D3873-1
Revision ID:
Item Name: Bushing

Accept

Setup Start
Stop

Start Date: 9/16/2011 **Start Qty:** 400.00
Required Date: 10/14/2011 **Req'd Qty:** 400.00
Reference:

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3873	B								
100		0.00							
Hardinge	**Memo**	0.00		11/10/05		400	0		
Hardinge CNC Lathe Small	1-TURN AS PER FOLIO FA806 & DWG D3873 , FOLIO REV: AA DWG REV:_____ 2-DEBURR AS REQUIRED								
110	QC2- Inspect parts off machine FAI/FAIB	0.00		11/10/05		400	0		
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 73831

Friday, September 16, 2011 11:43:35 AM

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Item Name: Bushing
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Required Date: 10/14/2011 **Req'd Qty:** 400.00
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Accept

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Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00	D.A 11/10/06			400	ϕ		
Quality Control									
130	Identify as per dwg & Stock Location: ST 88	0.00							
Packaging	Memo	0.00				SP 11-10-11.			
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00						11/20/11	
Quality Control									

MF 11-10-11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Friday, September 16, 2011 11:43:32 AM

Work Order ID: 73831

Parent Item: D3873-1

Parent Item Name: Bushing

Start Date: 9/16/2011 **Required Date:** 10/14/2011

Start Qty: 400.00 **Required Qty:** 400.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.625 303 Round Bar 0.625"		Purchased	No			100	f	15.2000	0.06	25.26316		11/10/05	

Location	Loc Qty	Loc Code
MAT028	15.2	
110167	3.2	
118400	12	
✓ M119009		

~~23.333'~~
24'

M303R0.625
M119009

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

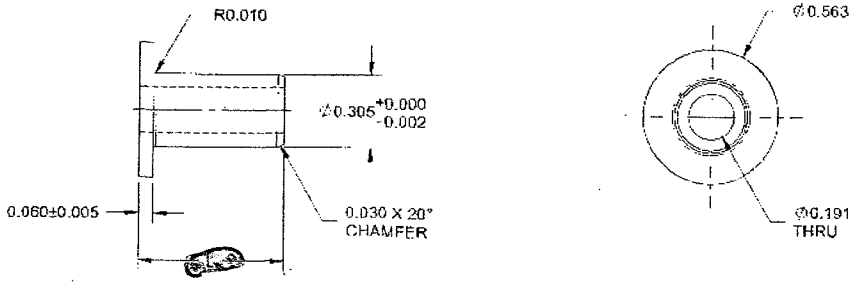
DART AEROSPACE LTD	Work Order:	
Description: Bushing	Part Number:	D3873-1
Inspection Dwg: D3873 **Rev:** B		Page 1 of 1

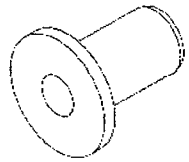
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.305	+0.000/-0.002	0.3033	✓		CNC 02	
Ø0.191	+0.005/-0.001	0.1915	✓		RQ 06	
Ø0.563	+/-0.010	0.562	✓			
0.060	+/-0.005	0.060	✓			
0.600	+/-0.010	0.601	✓			
R0.010	+/-0.010	R 0.010	✓			
0.030 x 20°	+/-0.010 x 0.5°	.030 x 20°	✓			

Measured by:		Audited by:	B.A	Preliminary Approval:	
Date:	11/10/05	Date:	11/10/06	Date:	

Rev	Date	Change	Revised by	Approved
A	09.05.20	New Issue	KJ	
B	10.11.05	Dimensions updated per Dwg Rev B	KJ	





D3873-X BUSHING

DART P/N	L	WEIGHT (lbs)
D3873-2	0.600	0.010
D3873-3	0.120	0.005
D3873-5	0.270	0.007

C

RELEASED
2011-09-12

NOTES:
1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR PER ASTM A582
REF DART SPEC M303R
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: PER TABLE

REV.	DESCRIPTION	BY	DATE
C	ADD D3873-2/-5/-7 (ZN B6-1 & B5-2)	RF	11.06.14
B	Ø0.562 WAS Ø0.63 (C3.1, TO FIT TRIBAC CIRT)	CP	10.07.22
A	NEW ISSUE	MB	09.01.07

DESIGN	CP
DRAWN	SC
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	11.06.14

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. D3873 REV. C
SHEET 1 OF 2
TITLE BUSHING
SCALE NTS

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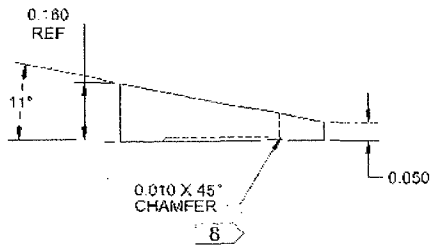

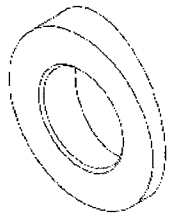

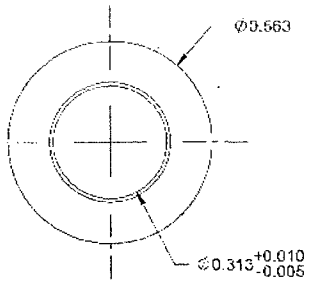

C **D3873-7 SPACER**

RELEASED
2011-09-12

NOTES:
1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR PER ASTM A582
REF DART SPEC M303R
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.005 lbs
8) IT IS ACCEPTABLE TO BE DEBURR

DESIGN	RF	**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN	RF	
CHECKED		DRAWING NO. D3873 — REV. C — SHEET 2 OF 2
MFG. APPR.		
APPROVED		TITLE: BUSHING — SCALE: NTS
DE APPR.		
DATE	11.06.14	

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